

Date: Friday, 5/25/2007 8:37:09 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	LUG		
Job Number	32654			Part Number	D2657		
Estimate Number	10338			Drawing Number	D2657 REV A		
P.O. Number				Project Number	N/A		
This Issue	5/25/2007	S.O. No.		Drawing Revision	A		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	6/12/2007	Qty:	30
Previous Run	32376A			Um:	Each		
Written By	<i>HJ 07.05.08</i>						
Checked & Approved By							
Comment	Est Rev: A New Issue 05-11-07 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"	
		Comment: Qty.: 0.1925 f(s)/Unit Total : 5.7740 f(s) Material: ASTM A36 steel bar 2.50" x 0.75" thick (M1010-B0.750 x 02.500) Batch <i>M104288</i>	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 2.200" long	<i>SD 07.06.13 30</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1  1-Machine per folio FA040 and Dwg D2657	
		2-Deburr	<i>SL / SD 07.06.13 30</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SL / SD 07.06.13 30</i>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>JL 07.06.13</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/06/18  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 32654

Part Number: D2657

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*EJ 07/06/18 30*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

*100% 07/06/18*

Job Completion



*U 07/06/18*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32654
Description: Lug	Part Number:	D2657
Inspection Dwg: D2657	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>SA</u>	Audited by:	<u>EN</u>	Prototype Approval:	N/A
Date:	01.06.13	Date:	07/06/13	Date:	

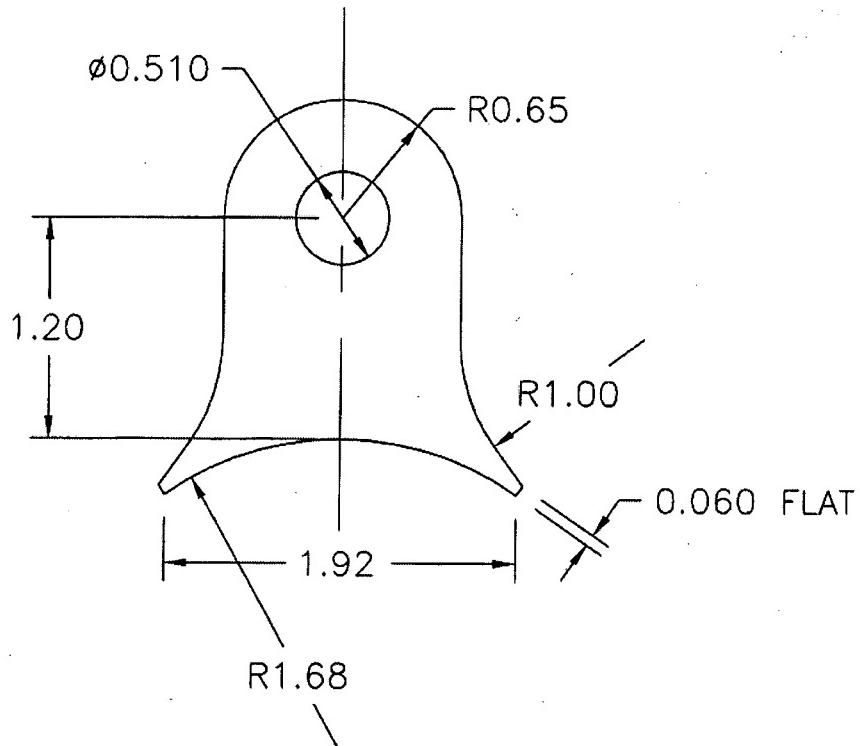
Rev	Date	Change	Revised by	Approved
A	03.12.23	New Issue	KJ/RF	FF



1 COPY  
DRAFT

DESIGN <i>DJY</i>	DRAWN BY <i>DJY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>S</i>	APPROVED <i>A</i>	DRAWING NO. D2657
DATE 97.11.03		TITLE LUG
A	97.11.03	SCALE 1:1 NEW ISSUE

RELEASED  
97/11/07 DS



BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~  
MATERIAL: ASTM A36 STEEL 0.375 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
PART IS SYMMETRIC ABOUT CENTER-LINE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *32654*